

Date: Monday, 6/5/2006 11:01:44 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING ANGLE
Job Number : 27418	
Estimate Number : 10509	
P.O. Number : NIA	Part Number : D2564
This Issue : 6/5/2006 S.O. No. : NIA	Drawing Number : D2564 REV. B1
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 25970	Material : NIA
Written By : <u>SEA COMMENT Below</u>	Due Date : 6/26/2006 Qty: 50 Um: Each
Checked & Approved By : <u>FA 06-06-05 U</u>	
Comment : Est:D 02-09-09 Re-format; Added FA276 Folio KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6207	Angle Extrusion 1x1x.125
-----	-------	--------------------------



Comment: Qty.: 0.0962 f(s)/Unit Total: 4.8090 f(s)
Angle Extrusion
Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)
(D6207) Batch: M18147

J.F. 06/06/13 (56)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

J.F. 06/06/13 (56)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA276 and Dwg D2564
Tumble and Deburr
Identify as D2564

J.F. 06/06/13 (56)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/13 (56)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

EP 06/06/13 x 56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RP Date: 06/06/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 11:01:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 27418

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

DONNE DAVID D.

10/6/14 (54)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10/6/14 (56)

Job Completion



OK 10/6/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

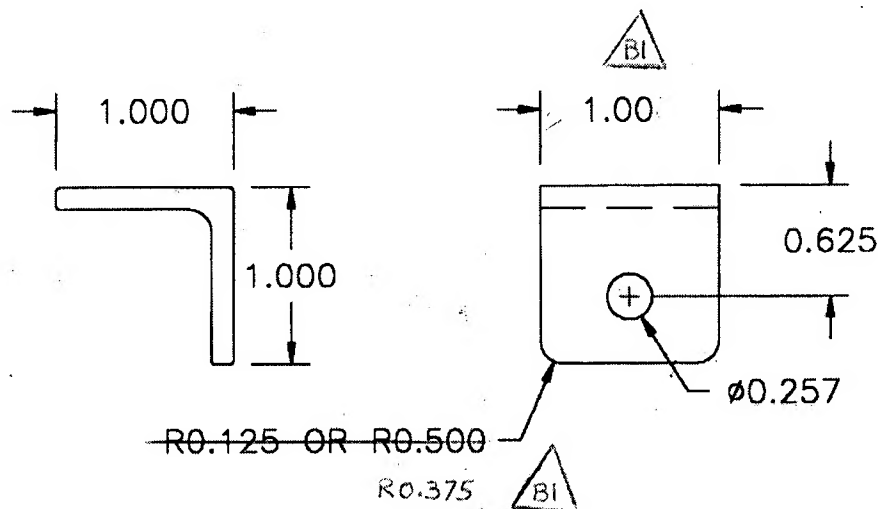
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN		DRAWN BY		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M		MIKE M		DRAWING NO. D2564	REV. B
CHECKED BW		APPROVED BW			SHEET 1 OF 1
DATE		TITLE			SCALE
96:04:30		MOUNTING ANGLE			1:1
B	97:05:06		MODIFIED DIMENSIONS		
BI	RF 02.09.17		R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000		

RELEASED
97/05/06 BW



NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING

Copyright 1996 by DART AEROSPACE LTD

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27418